

Date: Friday, 7/4/2008 12:48:24 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPAD	
Job Number	: 40275		Part Number	: D26483	
Estimate Number	: 10313		Drawing Number	: D2648 REV D	
P.O. Number	:		Project Number	: N/A	
This Issue	: 7/4/2008	S.O. No. :	Drawing Revision	: D	
Prsht Rev.	: NC		Material	:	
First Issue	: / /	Type	: SMALL /MED FAB		
Previous Run	: 34591		Due Date	: 7/30/2008	
Written By	:		Qty:	30	Um: Each
Checked & Approved By	:		B0807		
Comment	: Est: E 02/09/18 Re-format; Incorporated D2648-1 KJ/RF Est Rev:F Now on Waterjet 06-08-14 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S16GA	1010/1025/A21/6aA SHEET
		Comment: Qty.: 0.0788 sf(s)/Unit Total : 2.3625 sf(s) 1010/1025/A21/6aA SHEET (M1010S16GA) Batch: 105701 B 8-7-21
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D2648 *****CUT WITH FILE D2648-1***** Dwg Rev: B B 8-7-21 Prog Rev: B B 8-7-21
		2-Deburr if necessary B 8-7-21
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE B 8-7-21
4.0	QC8	SECOND CHECK
		Comment: SECOND CHECK S 08/07/01 (X33)
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary a/a Done at step 5/22 Cust 10/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

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Job Number: 40275		Part Number: D26483
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE		1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D2648-3
7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1		Qty Description Batch A/R560Hardcoat M106762 1-Weld as per Dwg D2648 using Jig DT 8210 2-Remove any weld that penetrated through Wearpadif necessary
8.0	QC10	VISUAL INSPECTION OF GROUND WELDS
Comment: VISUAL INSPECTION OF GROUND WELDS		EL 8-7-24
9.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		S 08/07/24 x33
10.0	POWDER COATING	POWDER COATING M 106442
Comment: POWDER COATING		Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 9:30 START TIME: 320 OF OVEN TEMPERATURE: 10:00 FINISH TIME: M. 1 08/7/26
11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		BL 08-07-28
12.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1		Identify and Stock Location: FP-17 FL 10/21/28 08-07-28 (33)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: WEARPAD

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Seq. #: Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/29

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

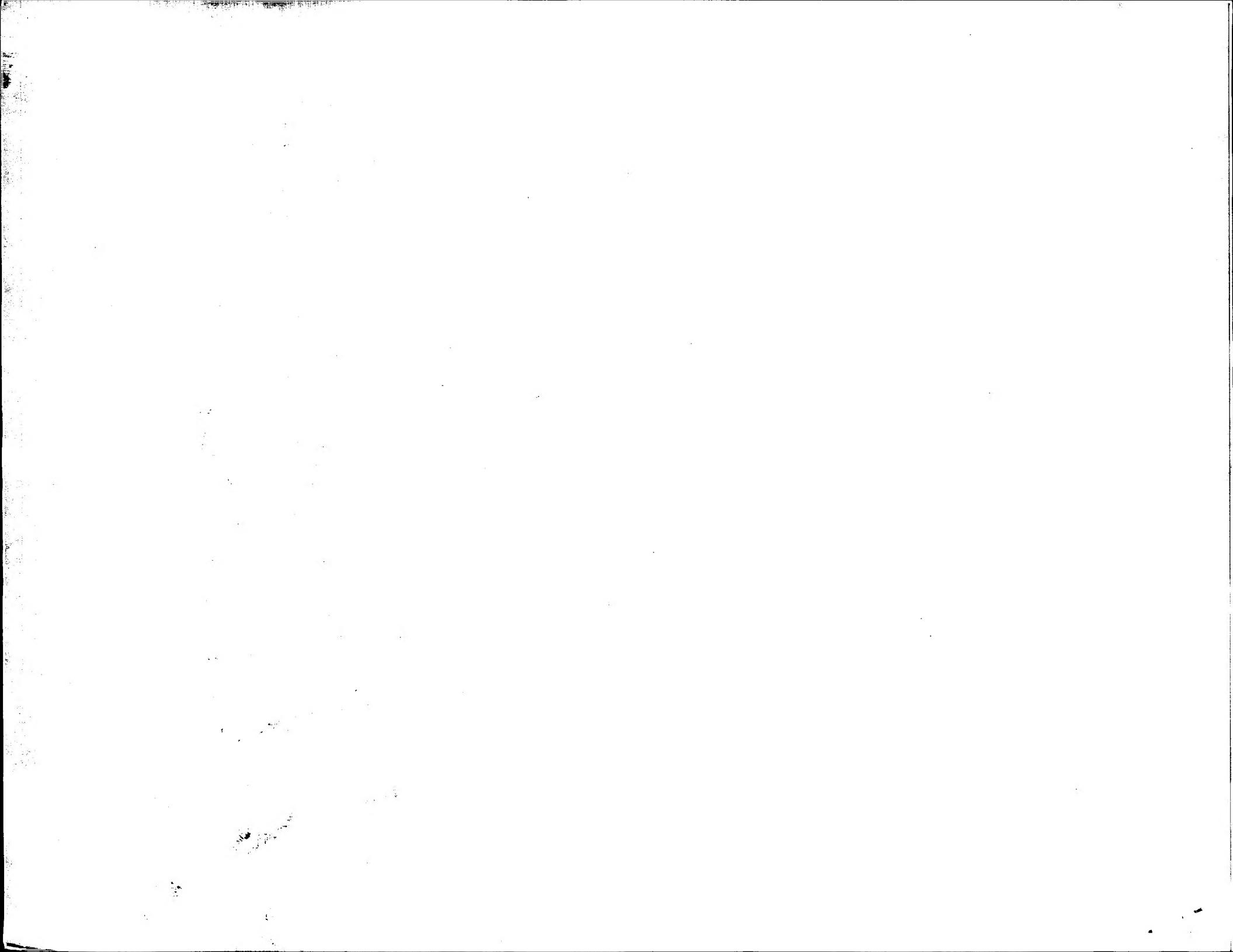
DART AEROSPACE LTD	Work Order:	40275
Description: Wearpad	Part Number:	D2648-3
Inspection Dwg: D2648	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

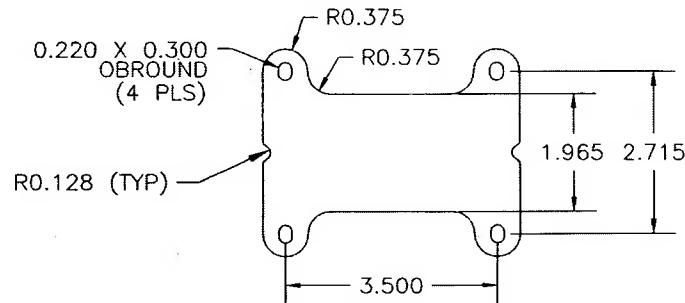
X First Article Prototype

Measured by: <u>HB</u>	Audited by: <u> </u>	Prototype Approval: N/A
Date: 8-7-21	Date: 08/07/21	Date: N/A

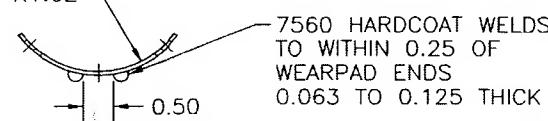
Rev	Date	Change	Revised by	Approved
A	06.10.16	New Issue	KJ/JLM	SM



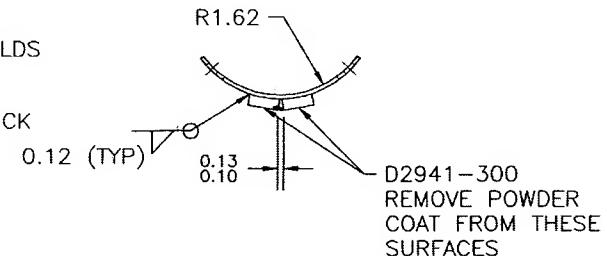
D2648-1 FLAT PATTERN



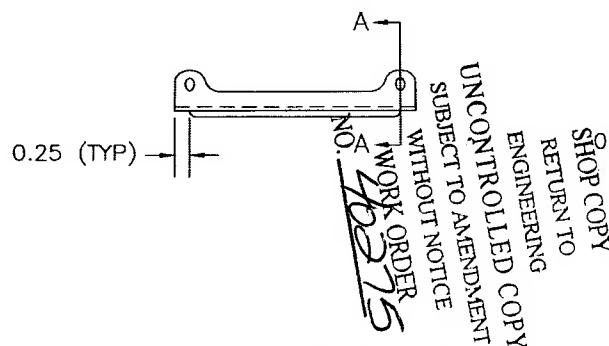
SECTION A-A



SECTION B-B

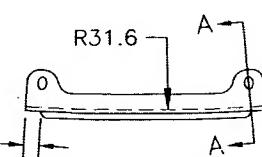


D2648-3 LONGITUDINAL BEND
(MADE FROM D2648-1)

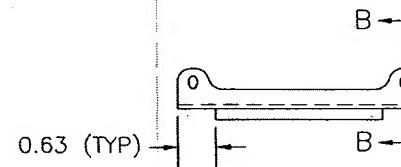


BREAK ALL SHARP CORNERS 0.063 MAX
MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)
FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

D2648-5 LONGITUDINAL BEND
(MADE FROM D2648-1)



D2648-7 LONGITUDINAL BEND
(MADE FROM D2648-1)



RELEASED
12.20.95

12.20.95
COPY
GIVEN

D	99.11.17	ADDED D2648-7
C	97.06.26	R31.6 WAS R19.6
B	97.05.30	ENLARGE OBROUND, 0.375 WAS 0.250
A	97.03.25	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLVIEW, WA
CHECKED	APPROVED	DRAWING NO. D2648 REV. D SHEET 1 OF 1
DATE		SCALE 1:2
99.11.17		WEARPAD